Dart Aerospace Ltd. Tuesday, 8/21/2007 3:43:29 PM Date: Kim Johnston User: **Process Sheet** : TUBE : CU-DAR001 Dart Helicopters Services **Drawing Name** Customer Job Number : 34183 : 11172 **Estimate Number حالہ**: **Part Number** : D22827 P.O. Number S.O. No. : NA - D2282 REV E : 8/21/2007 **Drawing Number** This Issue : N/A Prsht Rev. Project Number : MACHINED PARTS : E First Issue Type **Drawing Revision** : NA : 33417 Material Previous Run : 9/20/2007 Each Due Date Written By Checked & Approved By Removed from 9 Digit 05-12-02 JLM Comment **Additional Product** Job Number: Seq. #: Machine Or Operation: Description: 304 RD Tube .675 x .091W 1.0 M304TR0675W091 Comment: Qtv.: 0.0699 f(s)/Unit Total: 13.9860 f(s) Material: T304/T316 3/8 Schedule 40, Seamless, Ø0.675" OD, 0.091" wall thickness (M304TR0.675W.091) DTP 07/69/20 HARDINGE CNC LATHE SMALL 2.0 HARDINGE Comment: HARDINGE CNC LATHE SMALL 1-Turn as per Dwg D2282 and Folio FA190 2-Deburr 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK QC8 4.0 Comment: SECOND CHECK PACKAGING RESOURCE #* 5.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:

Dart Aerospace Ltd

W/O:		WORK ORDI	R CHANGES					
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NOTE: Date & initial all entries

Date:

Tuesday, 8/21/2007 3:43:29 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 34183

Part Number: D22827

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



SPECTION/W/O RELEASE



303

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



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Dart Aerospace Ltd

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NOTE: Date & initial all entries

QA: N/C Closed: ____ Date: __

DART AEROSPACE LTD	Work Order:	34183
Description: Handle Tube	Part Number:	D2282-7
Inspection Dwg: D2282 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.795	+/-0.010	0.796				
0.493	+/-0.010	0.488	/			
0.675	+/-0.010	0.796 0.488 0.671				
					*	

Measured by: DJP	Audited by:	Prototype	e Approval:	N/A
Date: 07/09/70	Date: 04	09/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.11.11	New Issue P/O D350-615-041	KJ/RF	
В	05.04.19	0.795 was 0.750	KJ/JLM	
С	06.03.15	Dwg Rev update	KJ/JLM ,	
D	07.07.17	Dimensions added per Dwg Rev. E	KJ/JLM	R
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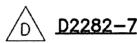
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CHECK	(ED/D	APPROVED	DRAWING NO. REV. E					
	4	(Mary)	D2282 SHEET 1 OF 2					
DATE	DATE		TITLE SCALE					
 05.0	05.06.07		HANDLE TUBES 1:1					
 Α		94.10.14	NEW ISSUE					
В		95.03.23	RE-DESIGN					
С		97.10.20	CORRECTED NUMBERING SCHEME					
D		05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750					
Ε		05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030					



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Ø0.675 (REF) Ø0.493 (REF)

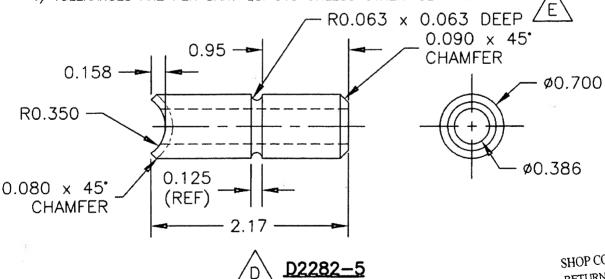
D2282-3



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY RETURN TO **ENGINEERING**

UNE ONTROLLED CONY SUBJECT TO AMENDMEN

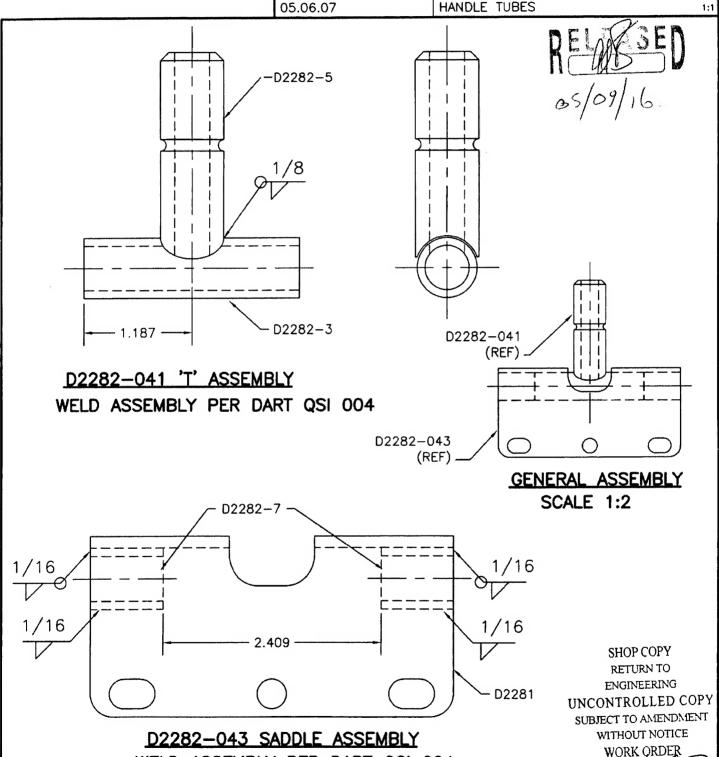
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DESIGN BW	DRAWN BY	DART AEROS HAWKESBURY, ONT	
CHECKED	APPROVED	DRAWING NO.	REV. E
l u	1 1115	D2282	SHEET 2 OF 2
DATE	1 100/	MLE	SCALE
05.06.07		HANDLE TUBES	1:1



WELD ASSEMBLY PER DART QSI 004

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